

8

7

THIS DRAWING IS UNPUBLISHED.

RELEASED FOR PUBLICATION

20

© COPYRIGHT 20

BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

REVISION

DESCRIPTION

2266218-1

A

FINE CRIMP HEIGHT ADJUST

2266218-2

A

FINE CRIMP HEIGHT ADJUST

2266218-5

A

FINE CRIMP HEIGHT ADJUST

2266218-6

A

NON-CRIMP HEIGHT ADJUST

2266218-7

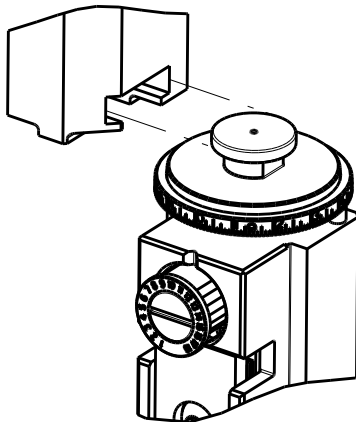
A

FINE CRIMP HEIGHT ADJUST

7-2266218-7

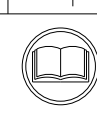
A

CRIMP TOOLING KIT



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS
408-10389



TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 2.5 LOW PROFILE CRIMP RECEPTACLE			
WIRE STRIP LENGTH 2.40-2.90 mm [.094-.114 IN]		INSULATION DIAMETER RANGE Ø1.40-1.60 mm [.055-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	MOLEX SPEC	-	-
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572313-1	08701039	1572313-5	456270002
1572313-2	08701045	1572313-6	456271002
1572313-3	39000160	1572313-7	08701047
1572313-4	98000242		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
22 AWG OR 0.35mm2		0.725+/-0.035 [.029+/- .001]		9.8	
24 AWG OR 0.20mm2		0.665+/-0.035 [.026+/- .001]		10.4	
26 AWG OR 0.12mm2		0.62+/-0.03 [.024+/- .001]		10.8	
28 AWG OR 0.08mm2		0.60+/-0.03 [.024+/- .001]		11.0	



- 1

RECOMMENDED SPARE PARTS
- 2

GREASE BEARING SURFACES LIGHTLY
- 3

LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266218-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266218-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266218-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266218-6
- 5

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62,180 & 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37,180 & 242.
- 7

GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8

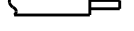
MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9

CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 10

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12

WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 5.08.

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 2.5 LOW PROFILE CRIMP RECEPTACLE			
WIRE STRIP LENGTH 2.40-2.90 mm [.094-.114 IN]		 INSULATION DIAMETER RANGE Ø1.40-1.60 mm [.055-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	MOLEX SPEC	ATS 639023100	-
	REV.C	-	-
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572313-5	456270002	1572313-6	456271002

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
22 AWG OR 0.35mm2		0.725+/-0.035 [.029+/- .001]		7.2	
24 AWG OR 0.20mm2		0.665+/-0.035 [.026+/- .001]		7.7	

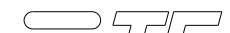
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

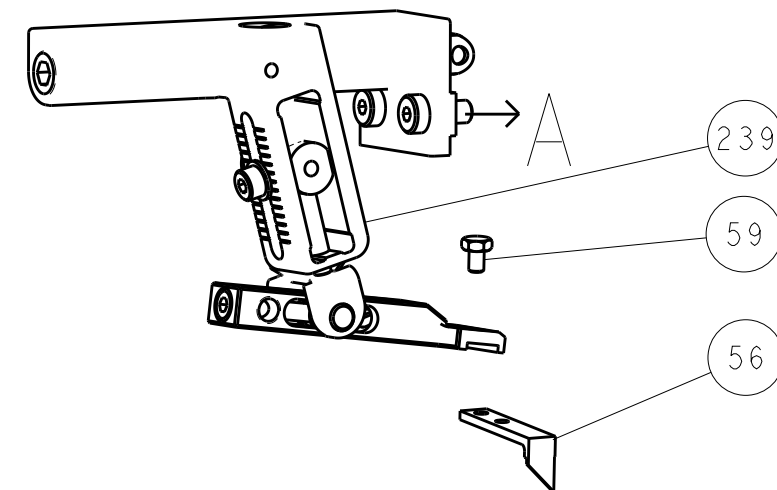
SET UP GAUGE 2119599-1	LOC A	DIS 66	REVISIONS						
			P	LTR	DESCRIPTION	DATE	DWN	AFVD	
				A	RELEASE	14MAR2014	XZ	GB	

-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG,IDENTIFICATION	213
-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	1	1	1-1752354-5	STANDOFF,HOLD-DOWN	180
-	1	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	1	1-455888-2	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1	1-1901681-3	HOLDDOWN, TERMINAL	51
-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	1-2119644-4	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	2-1752356-5	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-3	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1-1633139-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1-1633962-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	1	1	1	2-456402-9	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

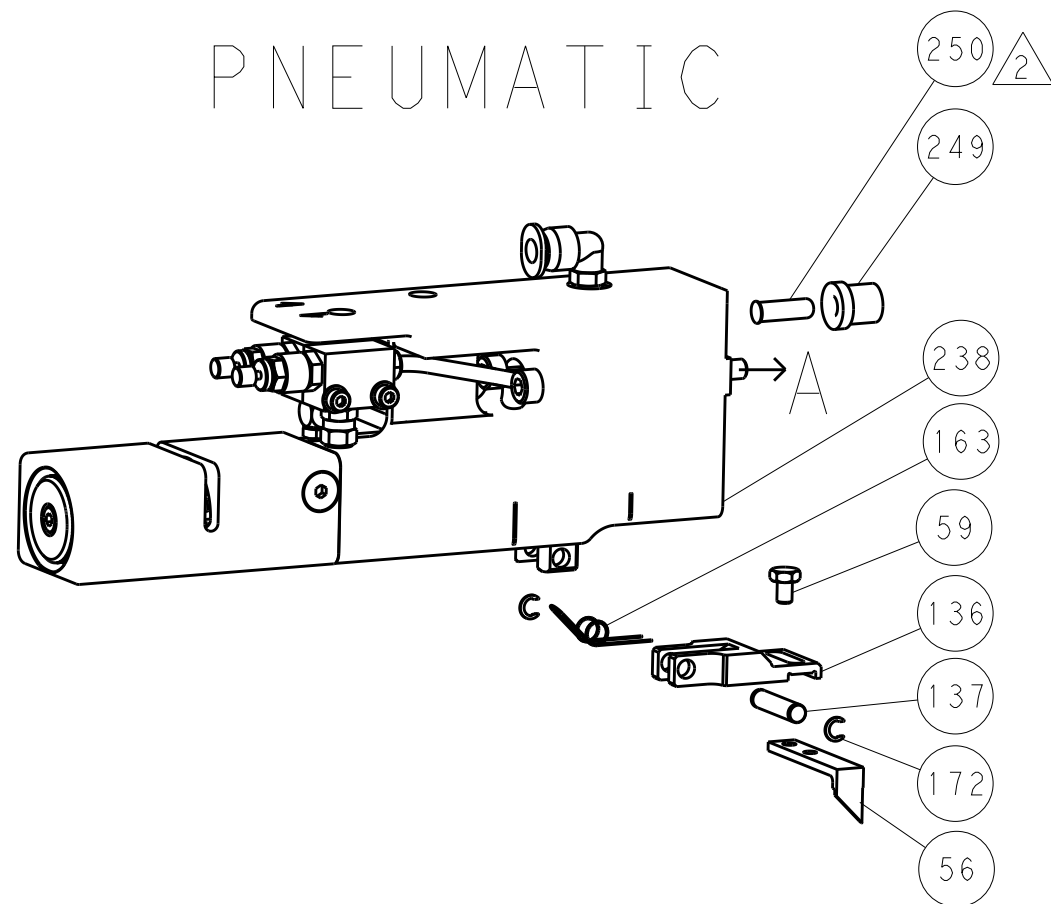
THIS DRAWING IS A CONTROLLED DOCUMENT FOR TECP ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE MANUFACTURING ORGANIZATION NO OTHER REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN X_ZHAO 21FEB2014		 TE Connectivity Harrisburg, PA 17105-3608	
				CHK L_ZHANG 21FEB2014			
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD T_FLIN 21FEB2014		NAME Ocean Side Feed Applicator	
		0 PLC ±.1 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		PRODUCT SPEC -		SIZE A	
				APPLICATION SPEC -			
MATERIAL -		FINISH -		WEIGHT -		CAGE CODE 00779	
						DRAWING NO ©=2266218	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 1 OF 4	
						REV A	

LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

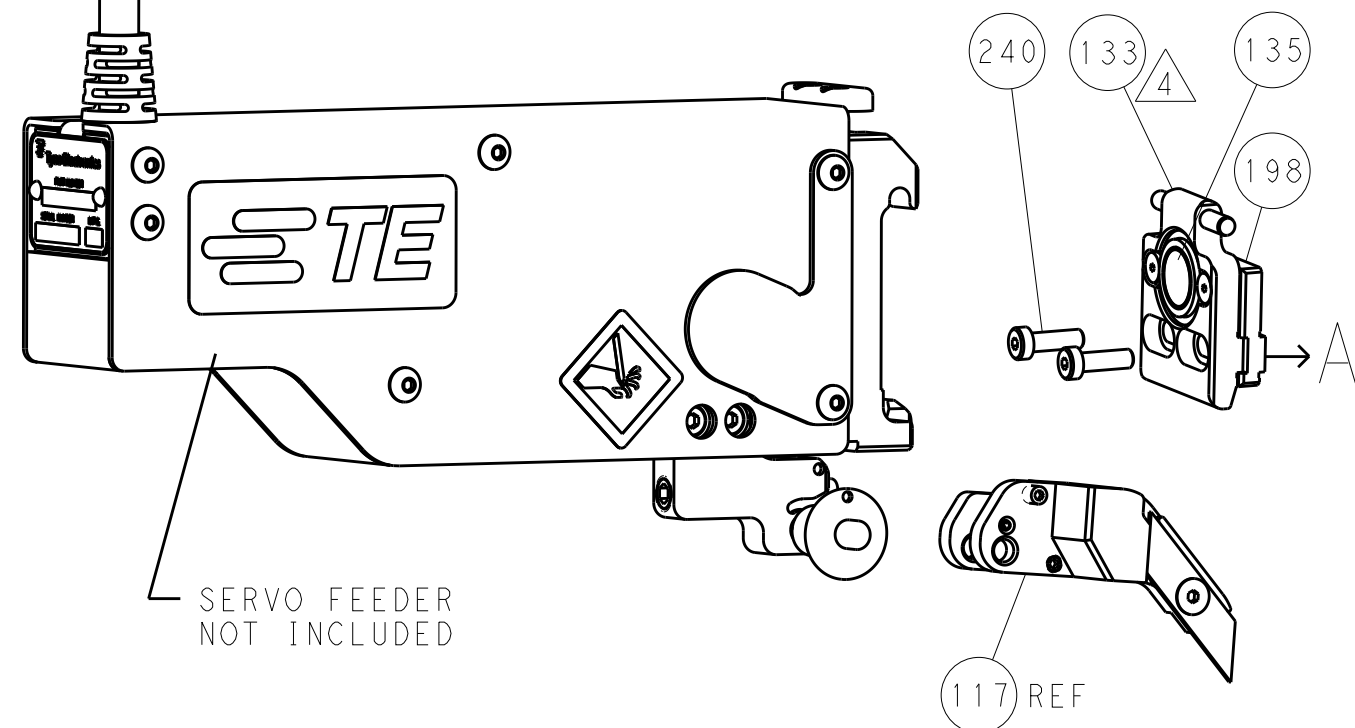
FEED TYPE
MECHANICAL



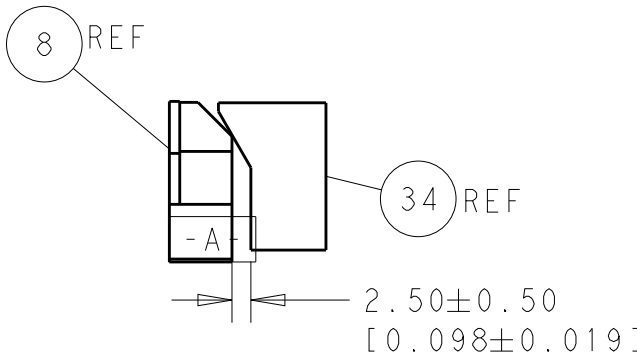
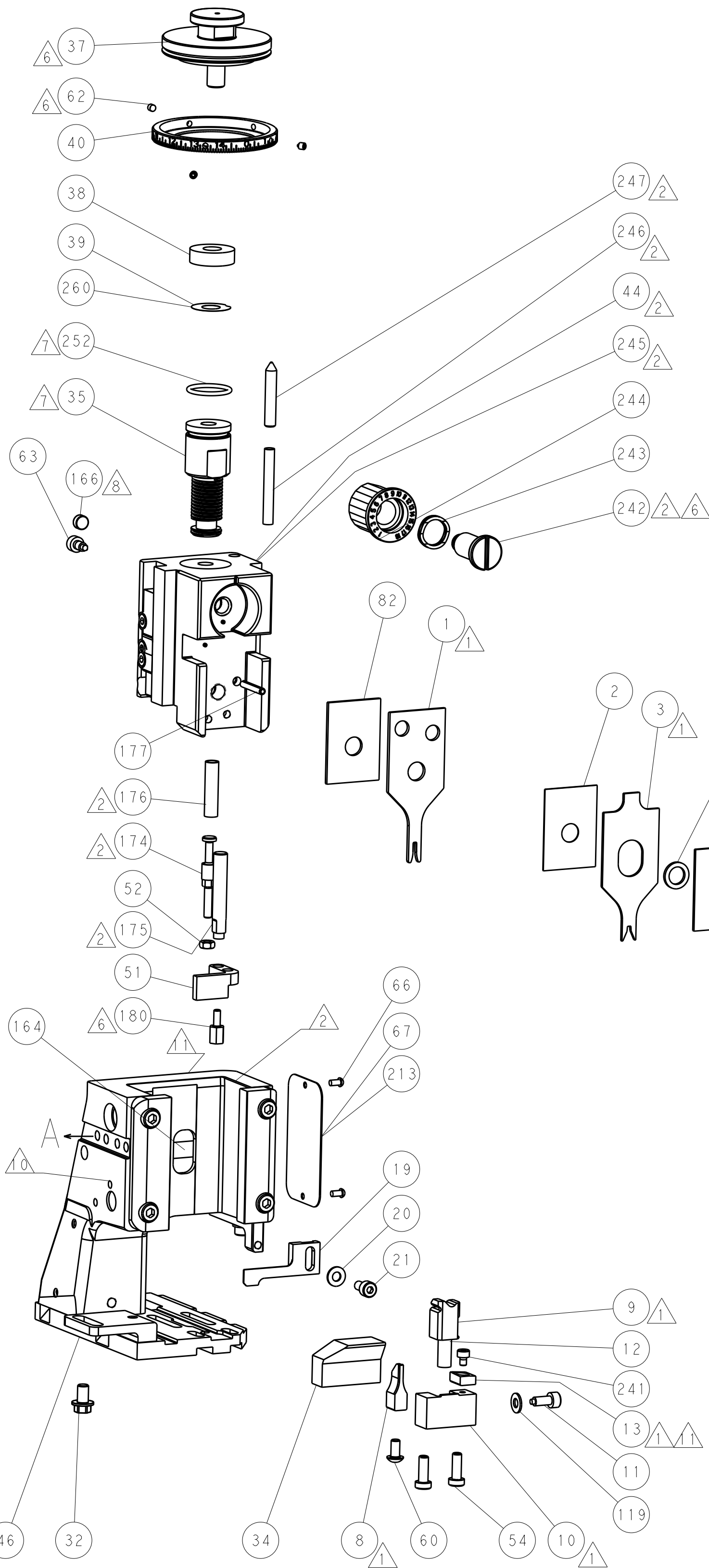
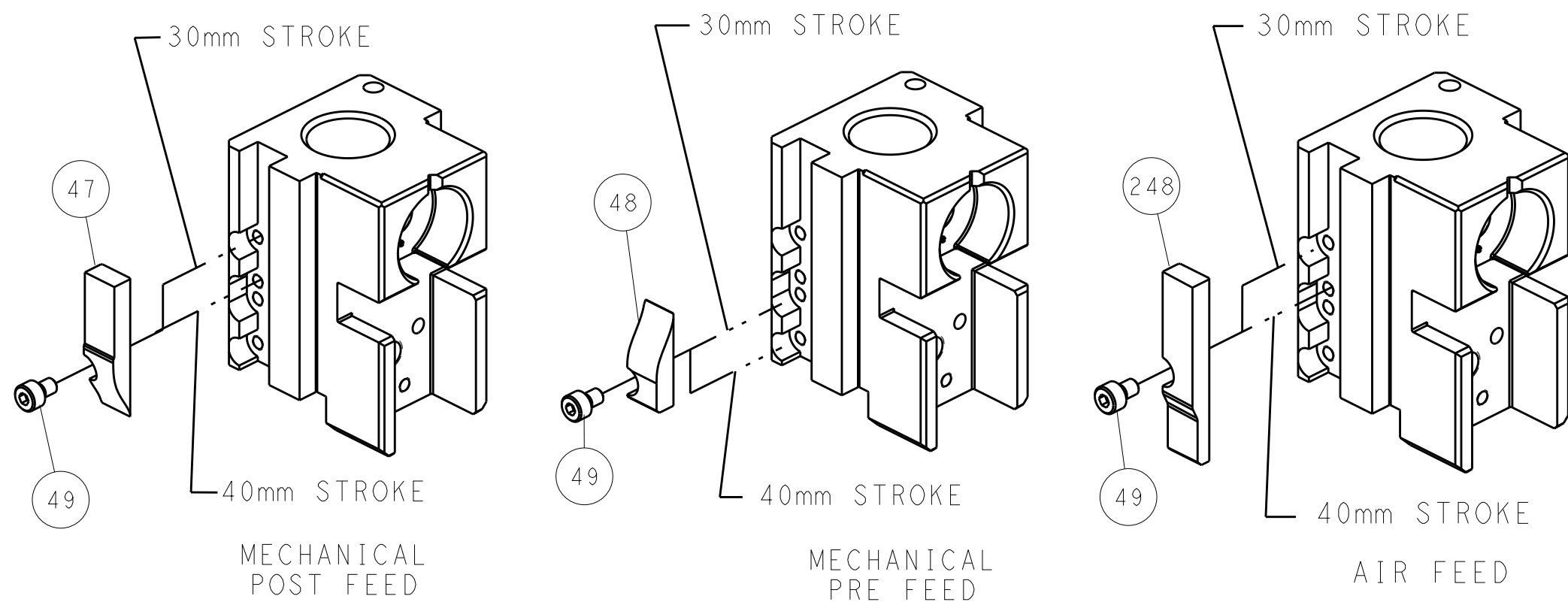
PNEUMATIC



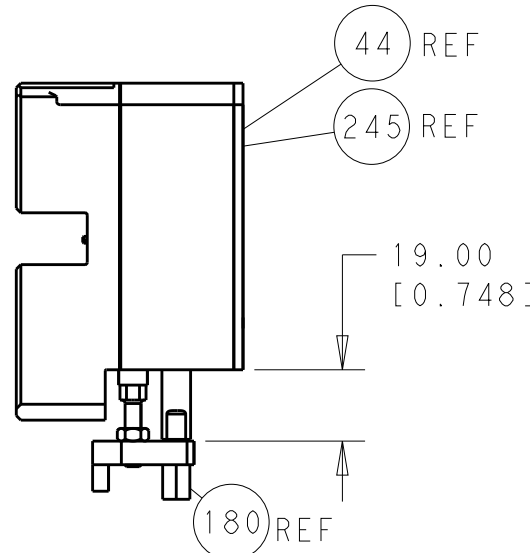
SERVO
LATCH PLATE



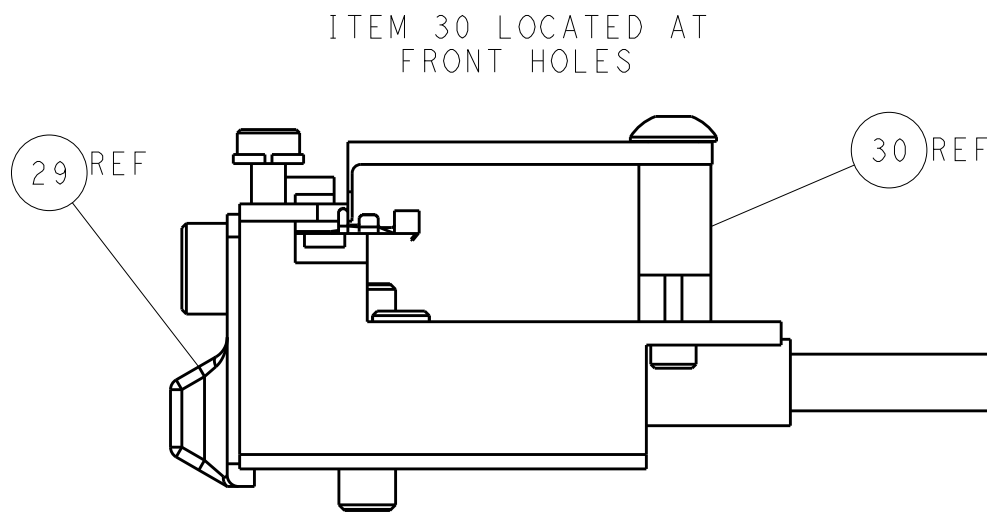
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



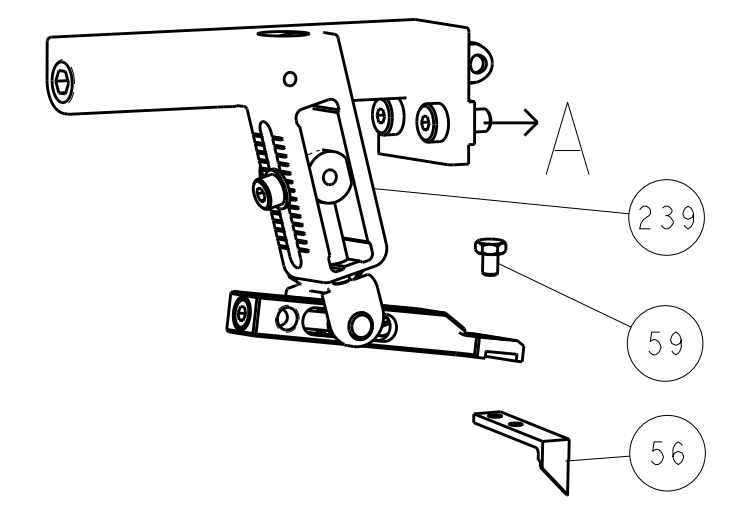
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

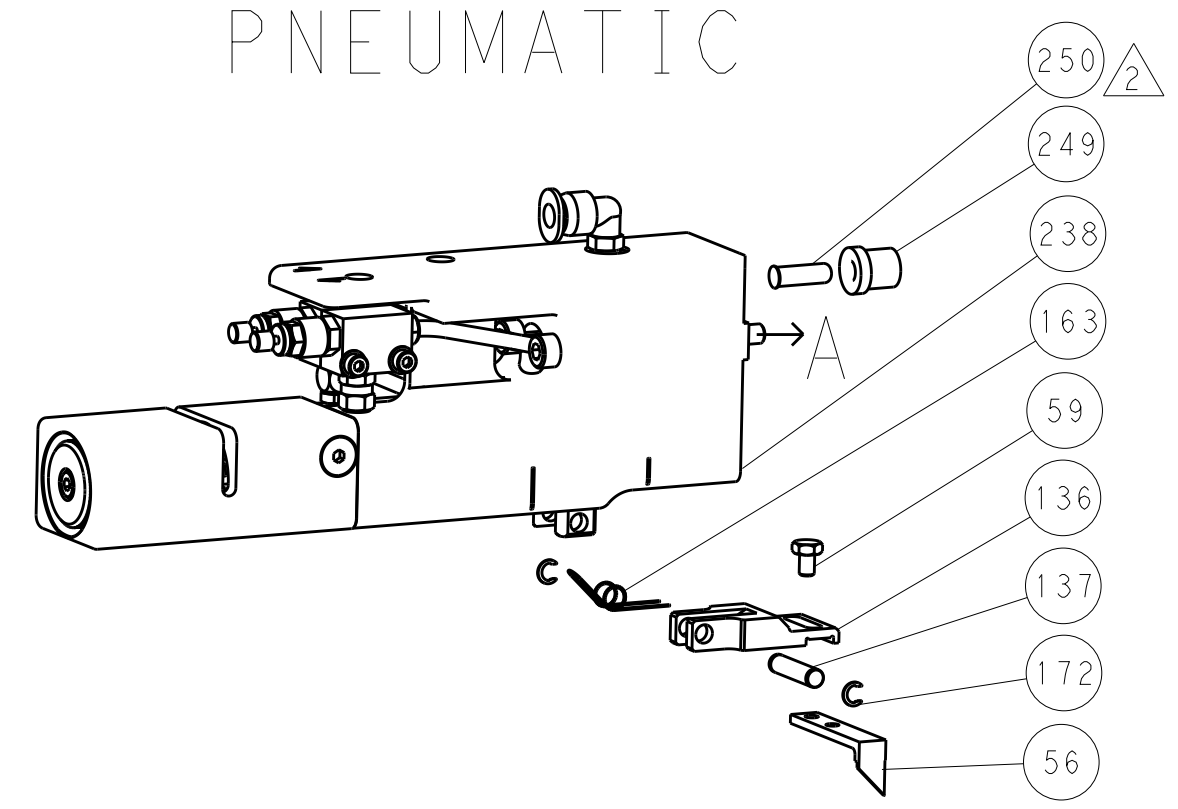
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN	X. ZHAO	21FEB2014	TE Connectivity	
		CHK	L. ZHANG	21FEB2014	Harrisburg, PA 17105-3608	
		APVD	T. ELBIN	21FEB2014	NAME Ocean Side Feed Applicator -<	

LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

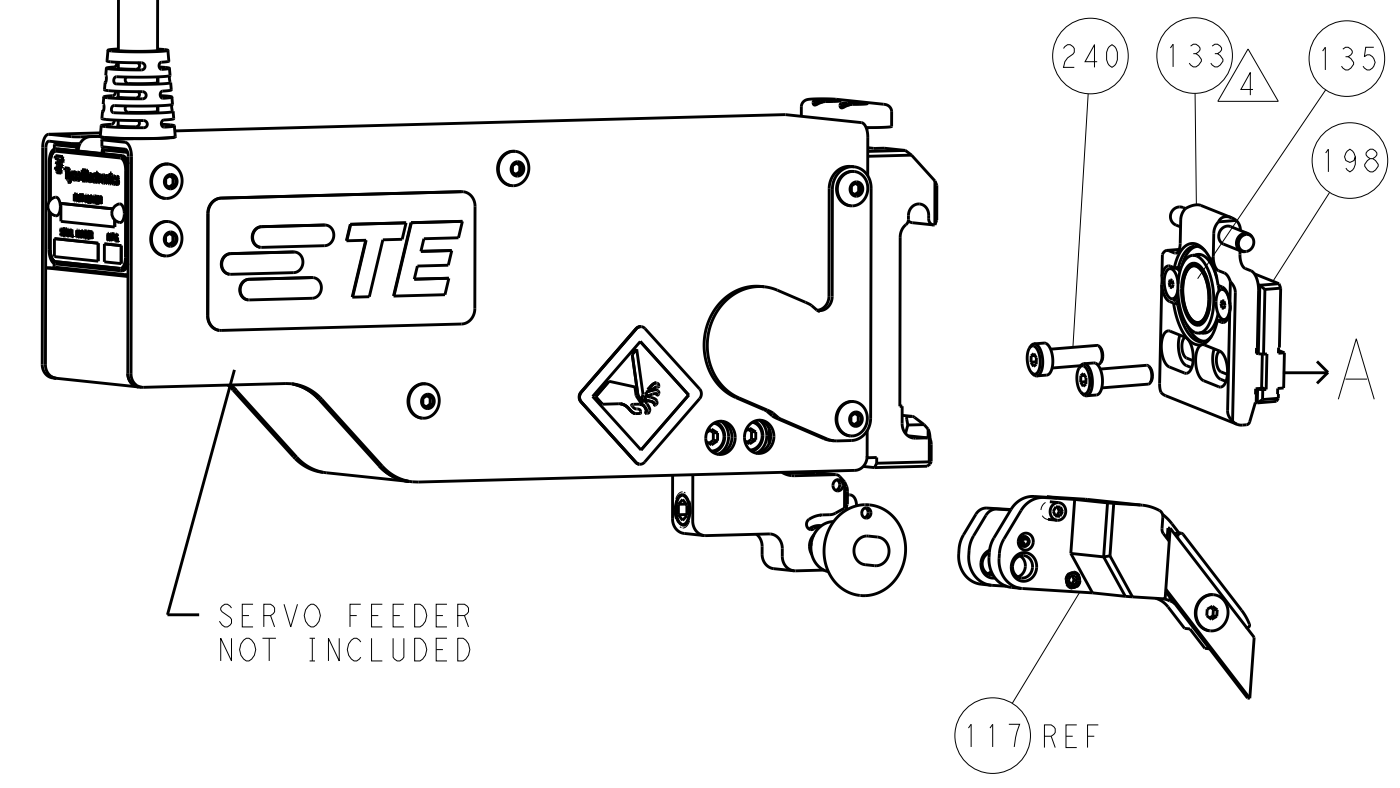
FEED TYPE MECHANICAL



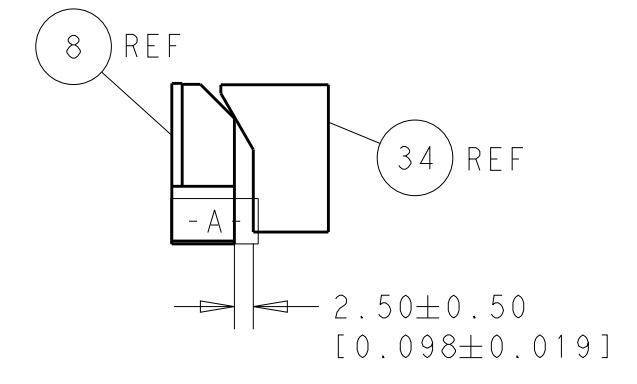
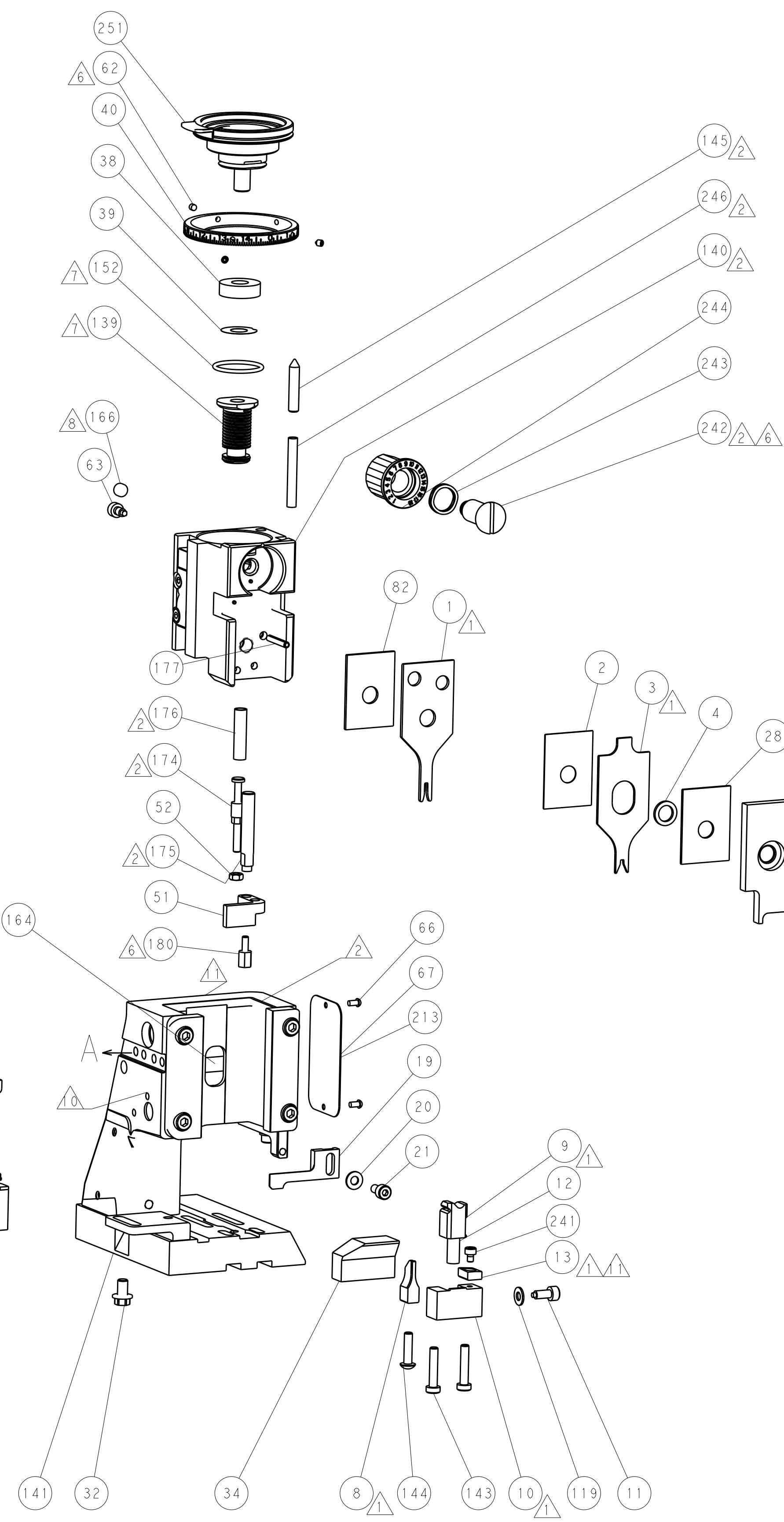
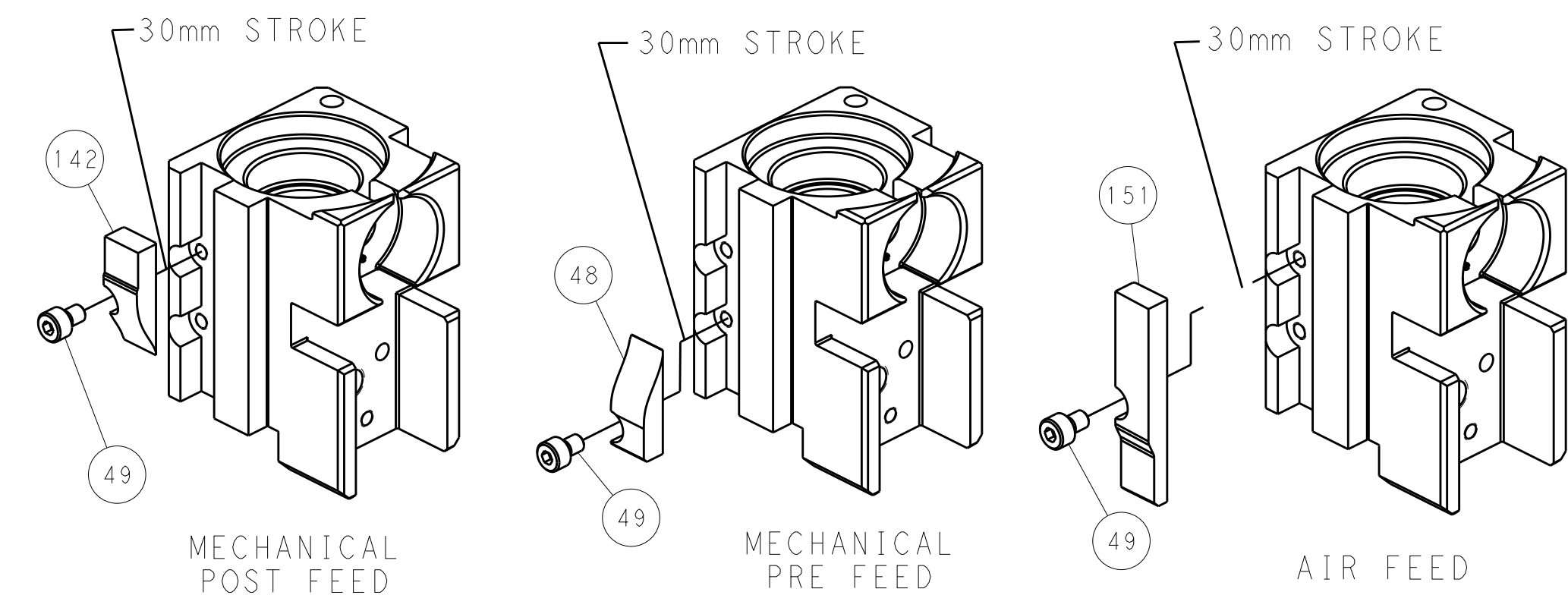
PNEUMATIC



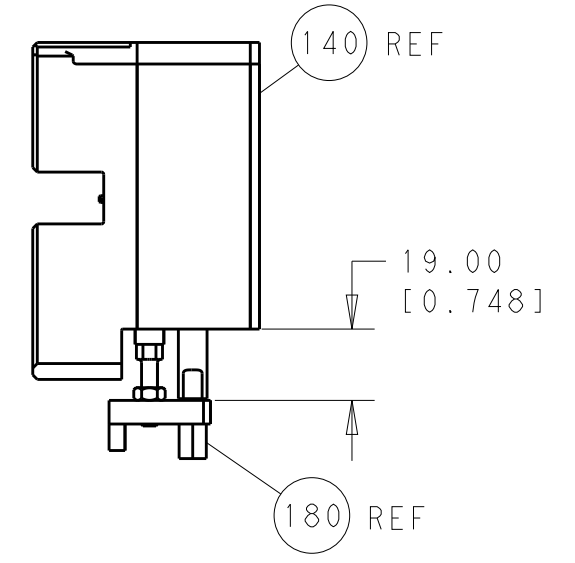
SERVO LATCH PLATE



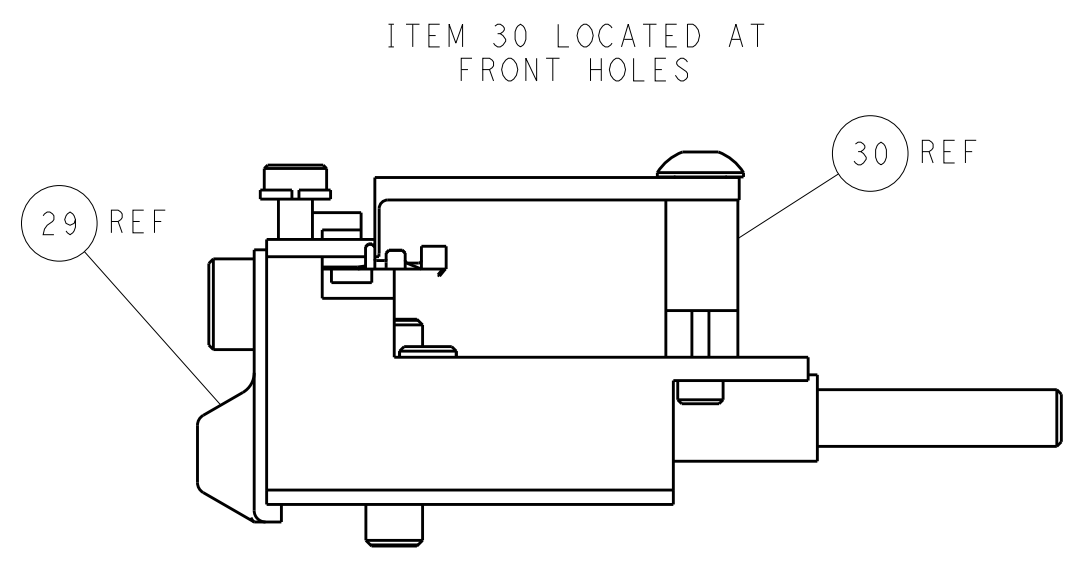
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

1. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION.		DWN X. ZHAO 21FEB2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 21FEB2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD T. ELBIN 21FEB2014	SIZE A	
0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001		PRODUCT SPEC	CAGE CODE 00779	
ANGLES FINISH		APPLICATION SPEC	DRAWING NO C=2266218	
MATERIAL		WEIGHT	Customer Accessible Production Drawing	
		SCALE 1:2	SHEET 4 OF 4	
		REV A		